

Fig. 1

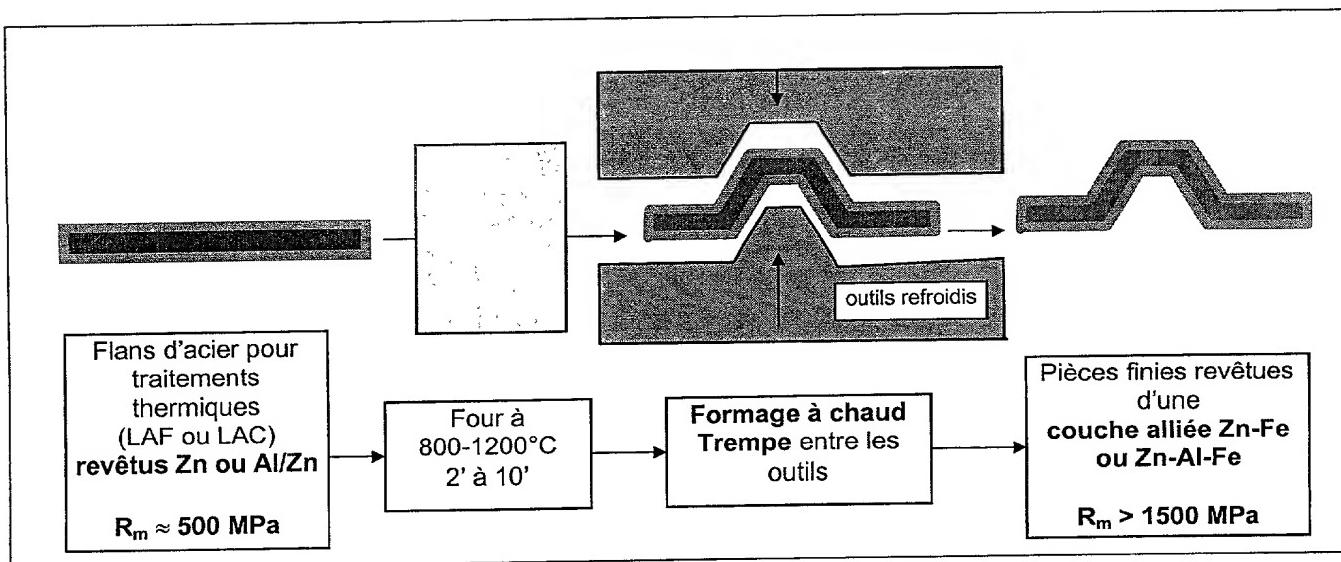
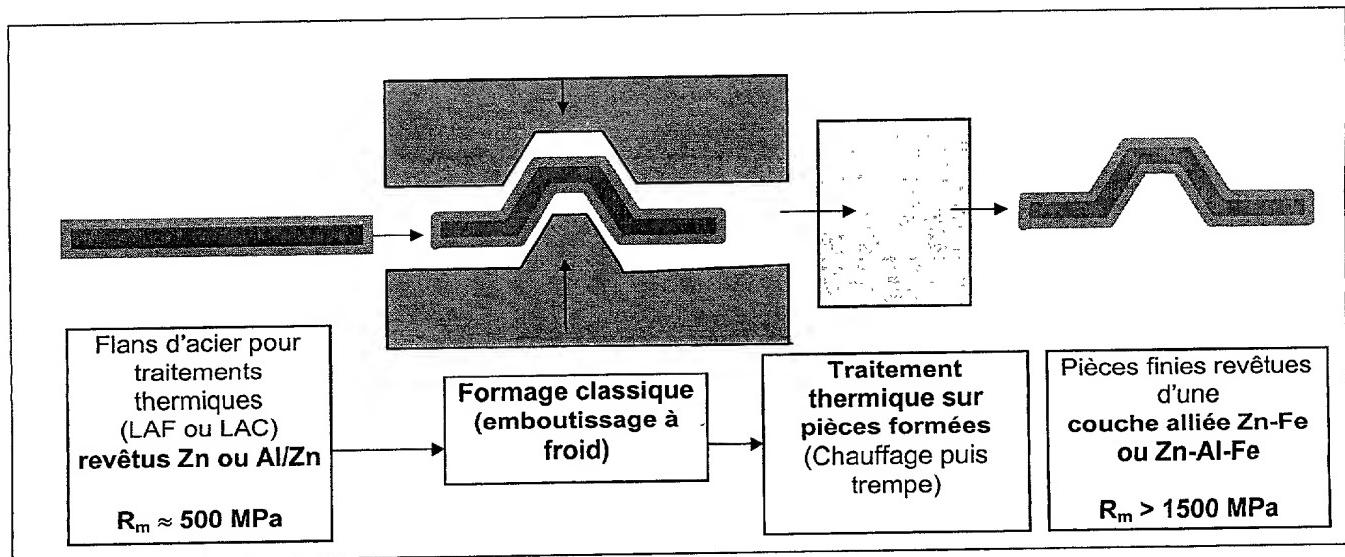


Fig. 2



**Fig. 1**

Cooled tools

Steel blanks for heat treatment (Cold or Hot Rolled) <b>with Zn or Al/Zn coating</b>  <b>ts = approx. 500 MPa</b>	Oven at 800-1,200°C 2 to 10 min.	<b>Heat forming Quenching between tools</b>	Finished parts coated with <b>Zn-Fe or Zn-Fe-Al alloyed layer</b>  <b>ts &gt; 1,500 MPa</b>
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**Fig. 2**

Steel blanks for heat treatment (Cold or Hot Rolled) <b>with Zn or Al/Zn coating</b>  <b>ts = approx. 500 MPa</b>	<b>Conventional forming (cold stamping)</b>	<b>Heat treatment on formed parts (Heating then quenching)</b>	Finished parts coated with <b>Zn-Fe or Zn-Fe-Al alloyed layer</b>  <b>ts &gt; 1,500 MPa</b>
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Fig. 3a.

Fig. 3b.

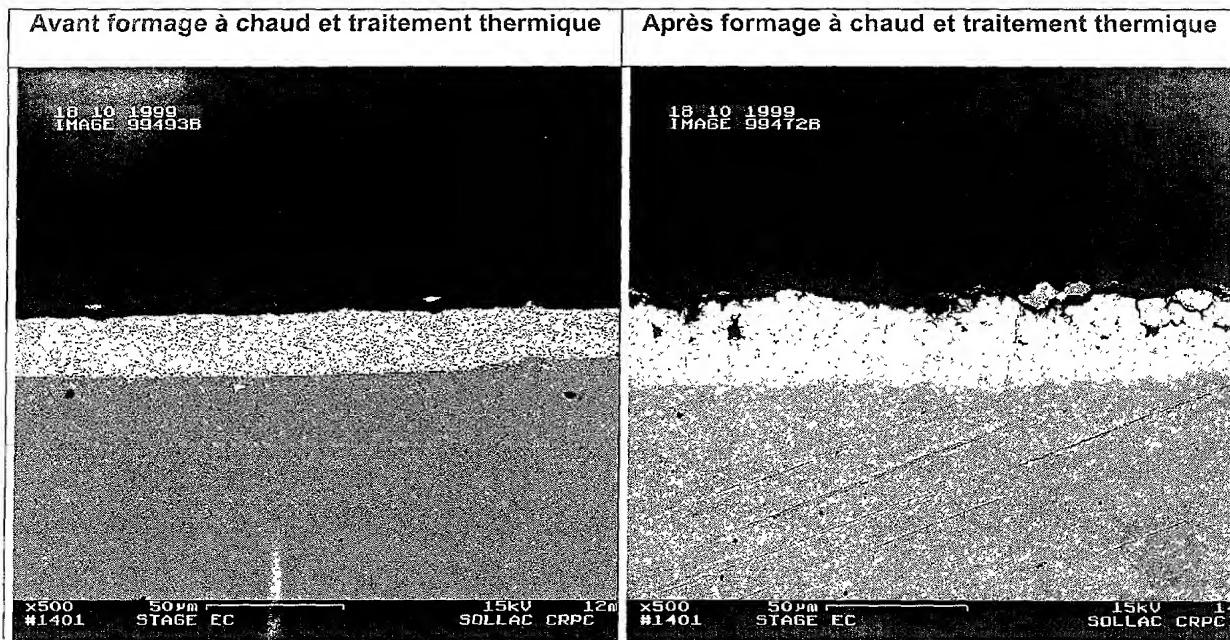
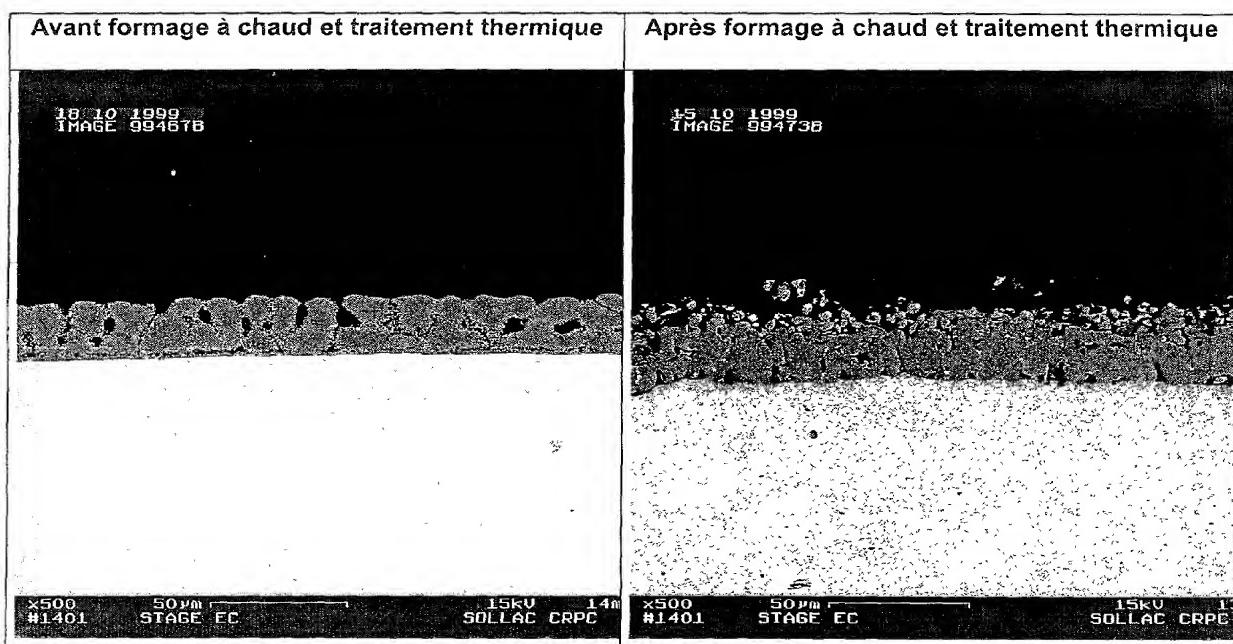


Fig. 4a.

Fig. 4b.



**Fig. 3a.**

**Before hot forming and heat treatment**

**Fig. 3b.**

**After hot forming and heat**

**Fig. 4a.**

**Before hot forming and heat treatment**

**Fig. 4b.**

**After hot forming and heat**